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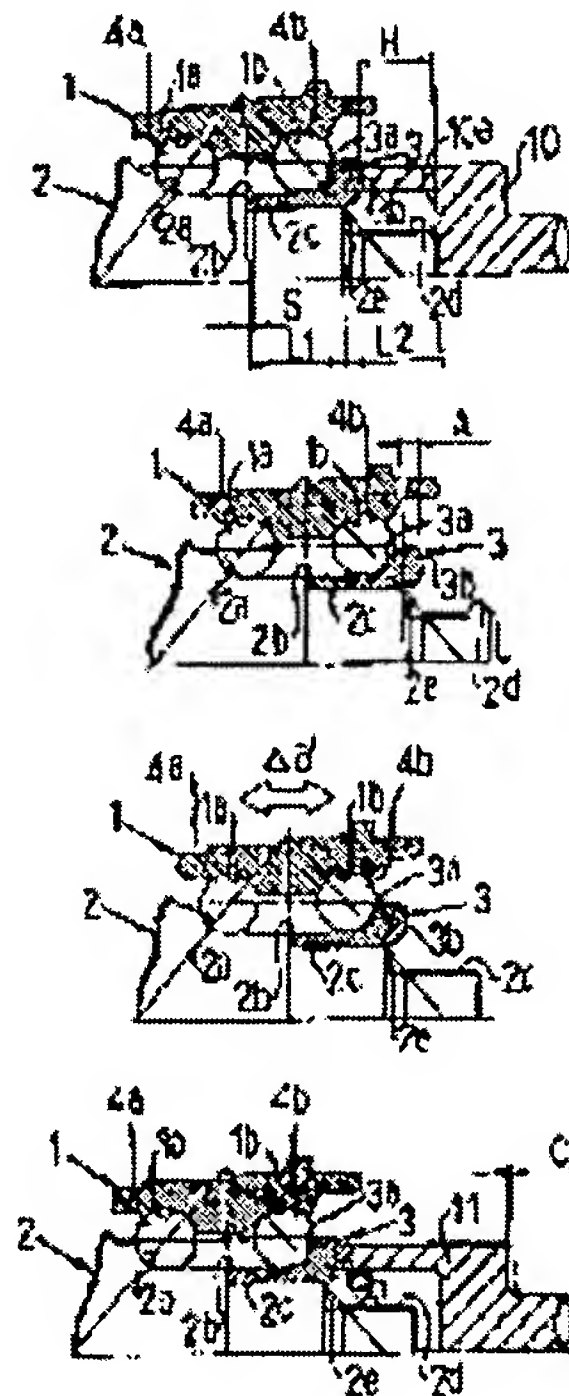
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## (54) MANUFACTURE OF BEARING DEVICE FOR AXLE

(57)Abstract:

**PROBLEM TO BE SOLVED:** To accurately provide a bearing axial gap by a method wherein when an inner ring is pressed in an axle, press-in is stopped once in short of a time when the inner ring makes contact with an axle shoulder part, and a movement amount when the outer ring is axially moved is measured, and thereafter, the inner ring in a stroke amount exceeding a movement amount is pressed in.

**SOLUTION:** The tip of a press-in jig 10 having a recessed part 10a having a given depth is brought into contact with the large part end face 3b of an inner ring 3. When the inner ring 3 is forcibly advanced toward the shoulder part 2b of an axle 2, at a point of time when the bottom of the recessed part 10a makes contact with the end of the axle 2, the inner ring 3 does not advance any more and press-in of the inner ring 3 is stopped once. An axial size A between the large part end face 3b and the reference surface 2e of the axle 2 is then measured and further, the outer ring 1 is axially moved and an axial movement amount  $\Delta a'$  is measured. Thereafter, the inner ring 3 is pressed in by the press-in jig 11 until the inner ring 3 is brought into contact with the shoulder part 2b, and an axial size



B between the large part end face 3b and a reference surface 2e is measured. From  $\Delta a = \Delta a' - (A - B)$ , a negative bearing axial gap  $\Delta a$  is determined. Thus, a stable bearing gap is maintained.

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## LEGAL STATUS

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